

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1-10. (Canceled)

11. (New) A device for charging casting devices with molten metal, comprising:

a crucible;

a metering unit having a metering pump with a pump part projecting into the  
crucible and a discharge pipe;

wherein the metering unit is designed as a crucible insert having a cover flange  
attachable to a cover of the crucible, and

wherein the pump part projecting into the crucible contains a pump pipe that  
extends through an associated passage opening of the cover flange and  
is connected to the discharge pipe, and the discharge pipe is held  
swivellably in an associated passage opening of the cover flange.

12. (New) The device of claim 11, wherein the metering pump is provided with a drive motor  
arranged outside of the crucible cover.

13. (New) The device of claim 11, wherein a pressure side of the metering pump is  
connected via a U-shaped connecting pipe with a lower end of the discharge pipe.

14. (New) The device of claim 12, wherein a pressure side of the metering pump is  
connected via a U-shaped connecting pipe with a lower end of the discharge pipe.

15. (New) The device of claim 13, wherein the connecting pipe is attached via a holder to a cover flange which is deployed on the crucible cover.
16. (New) The device of claim 14, wherein the connecting pipe is attached via a holder to a cover flange which is deployed on the crucible cover.
17. (New) The device of claim 15, wherein the cover flange is provided with penetrating openings for the pump pipe and the discharge pipe.
18. (New) The device of claim 16, wherein the cover flange is provided with penetrating openings for the pump pipe and the discharge pipe.
19. (New) The device of claim 11, wherein the discharge pipe is provided about half way up with an outlet connection projecting laterally from it.
20. (New) The device of claim 19, wherein a supply opening for protective gas is provided in the discharge pipe above the outlet connection.
21. (New) The device of claim 19, wherein the discharge pipe is provided in an area outside of the crucible cover with a thermal insulation at least up to the outlet connection.

22. (New) The device of claim 19, wherein the discharge pipe is provided in an area outside of the crucible cover with a heating system at least up to the outlet connection.
23. (New) The device of claim 21, wherein the discharge pipe is further provided in the area outside of the crucible cover with a heating system at least up to the outlet connection.
24. (New) The device of claim 13, wherein the connecting pipe is provided with heat resistant plug connections for the pressure side of the metering pump and for the discharge pipe respectively.
25. (New) The device of claim 14, wherein the connecting pipe is provided with heat resistant plug connections for the pressure side of the metering pump and for the discharge pipe respectively.